Work Order April-05-13 1:17:		24		*993	24*						Page 1
Revision ID:	03126-3 Bracket			Accept	*N900	040	100	)* s	Setup Sta	I VI	S1* S2*
		Start Qty: 4.00	*4*		Cust Item	ID:					
Required Date: 4	/19/13	Req'd Qty: 4.00	*4*		Customer:						
Reference:		· · · · · · · · · · · · · · · · · · ·						F	Run Sta	rt *NI	D4*
Approvals:	Process Plan:	MLJ	Date:13 -04-0	$\mathop{\mathcal{S}}$ Tooling:	<b>D</b>	ate:			Sto		R1*
•	QC:		Date:	<b>SPC (Y/N):</b>		ate:			Sit	" *N	R2*
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revis	ion Nbr									
D3126	Rev A	.1									
00				0.00							
*100* Waterjet	Ī	FLOW WATER JET  Memo		0.00				_4			JM13-10-2
FLOW CNC Waterjet			er Dwg D3126 Dwg Rev	v: A   Prog Rev! A	2-						
304.030		Deburr if n	ecessary	<u> </u>							)
110	(	QC2- Inspect parts off r	machine FAI/FAIB	0.00							
*11 <b>∩</b> *		Memo		0.00				4	_0_		JM13-10-2
Quality Control											
							•	*			
120	,	OCS Increat parts (10)	and shook	DAS 0.00 <b>27</b>							
120 *4 0 0 *	,	QC8- Inspect parts - sec	Lond Check	9-89				Y			
*120* oc		Memo		0.00 13 10 2	D	•				<del></del>	

Quality Control

											DQA:	Date	e: _	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	O	NFORM	AANCE / UPDA		•		-	
											QA Closed:	Date	e:	
NA - ol Ood						DISPOSITION				AGAINST DEF	PARTMENT	PROCESS		
Work Orde	er: .			<del></del>		Rework	1		Skid-tube (	Crosstube		Water Jet	$\neg$	Engineering
Part N	No.					Scrap			<b>j</b>	Small Fab	Pro	d. Eng. Coor.	┨	Quality
	•					Use-as-is	1		noforming	Finishing	Rec/Stor	e/Packaging		Other
NCR N	No.					Work Order Update			Large Fab C	Composite		Supplier		
													<b>-</b>	
Root						ption of work order update	!	nitial	Action	i	Sign &			001
Cause		Date	Step	Qty	(	or Non-conformance	Ch	ief Eng	Descript	ion	Date	Verification	-	QC Inspector
Doc/Data	Щ											ı		
Equip/Tooling	Ш													
Operator														
Material														
Setup			l											
Other														
Process	Щ													
Supplier	H									;				
Training	Ш													
Unapproved	Ш		<u> </u>		7	· •	<u> </u>	TCATE	CODY					
						General	AUL	T CATE	JURY		· · · · · · · · · · · · · · · · · · ·			
Landi						Bend	Г	Grain			Ovalized	ſ		Pressure/Forced
	ь—	Bending Centre No	st Cancar	atric to	0/5	BOM/Route	$\vdash$	Hardwa	ro	<b> </b>	Over/Under	tolerance		Temperature/Cure
	$\vdash$	Cracks	or concer	יטו אווונ	U/3  -	Broken/Damaged	-	-{	on Incomplete	<b>}</b>	Part Incorre	<del> </del>		Weld
		Crushed/	Crimpod		-	Burrs	$\vdash$	4	ions Incomplete/Unc	<b> </b>	Part Lost/Mi	- H		Wrong Stock Pulled
	_	Cuffs	стипреа,		<del> </del>	Contamination	-	Mainte	·	<u> </u>	Part Moved	, Samp		177. 37. 6 3030. 7 47.04
	-	Heat Trea	+		-	Countersink	-	Mislabe			Positioned V	Vrong		
	$\vdash$	Inspection		Tuhe	$\vdash$	Cut Too Short		Misread		-	Power Loss/			Other
		IIIIshacrioi	a arath iii	iune	L	Jear 100 3001		VII SI Cat	4		]. 0 ** (1 (033)	8-		1

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes

Drawing

Finish

Folio

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 99324  April-05-13 1:17:41 PM				*9932			Page 2			
Item ID: Revision ID: Item Name:	D3126-3 Bracket			Accept	*N900	04010	<b>^</b> *	Setup Start Stop	*NS1* *NS2*	
Start Date: Required Date: Reference:	4/04/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				
Approvals:	Process Pl	an:	Date:	Tooling: SPC (Y/N):		ate:	.] - - ·	Run Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code			Reject Insp. Number Stamp	
*130* Brake NC			cessaryForm on CNC brak entify as D3126-3Scribe D	0.00	3126		4			3
140 *140* QC Quality Control		QC5- Inspect part compl	eteness to step on W/O	0.00 PAS 9-89 0.00 3 10 3	9		<u> </u>			
150 <b>*150*</b> Packaging		Identify as per dwg & St Memo	ock Location: <u>MAT</u> LG	0.00			-4x	DAS / 28 / 9-89	13-10-29	

Packaging

											DQA	۸: D	ate:	
NCR:	Yes	/ No			·	WORK ORDER NON-	COI	NFORM	AANCE / UP	DATE	QA Closed	 I: D	ate:	
				o medie		DISPOSITION				AGAINST DE				
Work Ord	er: _					ļ	٦		[		1	Water Je	. [	
Part I	No				<del> </del>	Rework Scrap Use-as-is		ا Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-3	od. Eng. Coo ore/Packagin	 g	Engineering Quality Other
NCR	No					Work Order Update	_		Large Fab	Composite	J	Supplie	r[	
Root					Descri	ption of work order update		Initial	Ac	tion	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verificati	on	QC Inspector
Doc/Data	Ш				ļ									
Equip/Tooling														
Operator											İ			
Material	Ш													
Setup	<u> </u>													·
Other														:
Process	Ш						1							
Supplier					-									
Training														
Unapproved							$oldsymbol{\perp}$			J. 12	<u> </u>			
							AUI	T CATE	GORY					
Landi	ng Ge	ear				General		1		_	7		_	7
	∐E	Bending			<u> </u>	Bend		Grain			Ovalized		<u> </u>	Pressure/Forced
		Centre No	t Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Und	er tolerance		Temperature/Cure
		Cracks				Broken/Damaged		4 '	on Incomplete		Part Incor			Weld
		crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	/Unclear	Part Lost/I	Missing	L	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance	Ĺ	Part Move	ed .		
	<del>∏</del> ⊦	leat Trea	t			Countersink		Mislabe	led		Positioned	f Wrong	_	-
		nspection	Strip in	Tube		Cut Too Short	Г	Misread	d		Power Los	s/Surge		Other

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde		9324		*99?				Page 3		
Item ID: Revision ID: Item Name:	D3126-3 Bracket			Accept	*N900	<b>040100</b>	<b>)*</b> Setu	p Start Stop	*NS	
Start Date: Required Date: Reference:	4/04/13 4/19/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item I Customer:	D:				
Approvals:	Process P	lan:	Date:	Tooling:	D:	ate:	Run		*NF	<b>?1</b> *
	QC:		Date:	SPC (Y/N):	D:	ate:		Stop	*NF	?2*
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plan Code			-	Insp. Stamp
160		QC21- Final Inspection	Work Order Release	0.00				2	2/1-/	
*160* QC		Memo		0.00			7)/*	"M 13	3/10/30 	· 

MF 13-10-29

		DQA:	Date:	
NCR: Yes / No	WORK ORDER NON-CONFORMANCE / UPDATE		•	
,	·	OA Closed:	Date:	

											QA Closed.	Date	
Work Orde	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part 1	-	· · · · · · · · · · · · · · · · · · ·				Rework Scrap	]		id-tube chining	Crosstube Small Fab	Pro	Water Jet d. Eng. Coor.	Engineering Quality
NCR I	No					Use-as-is Work Order Update	]   T <sup>1</sup>		orming rge Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root					Descri	ption of work order update	Initia	ial	A	ction	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chief	Eng	Des	cription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling													
Operator													
Material	Ш												
Setup	Ш												
Other				ļ				ļ					
Process	Ш		ļ					1					
Supplier	Ш												
Training	Ш												
Unapproved				<u> </u>	<u> </u>						<u> </u>		
							AULT C	ATEGO	RY				
Landi	ing G	ear				General	<b></b>			<del></del>	<b>-</b> 1	F	
	-	Bending			<u> </u>	Bend	Gra				Ovalized	L	Pressure/Forced
	-	Centre No	ot Conce	ntric to	O/S	BOM/Route	<b></b>	rdware			Over/Under	<b>-</b>	Temperature/Cure
	$\vdash$	Cracks			_	Broken/Damaged	· ·	•	Incomplete	<u> </u>	Part Incorre	<del> </del>	Weld
		Crushed/	Crimped.			Burrs	$\vdash$		is Incomplete	·/Unclear	Part Lost/M	_	Wrong Stock Pulled
	Н	Cuffs			Ĺ	Contamination	$\vdash$	aintena		<u> </u>	Part Moved		
	$\boldsymbol{\vdash}$	Heat Trea				Countersink		slabeled	i		Positioned \	_	$\neg$
	-	Inspectio		Tube	<u> </u>	Cut Too Short	<b>—</b>	sread			Power Loss,	'Surge	Other
	$\vdash$	Ripples in			<u> </u>	Drill Holes	$\mathbf{H}$	fset					
	$\vdash$	Torque W			n	Drawing		it of Cali					
	$\vdash$	Turning S			-	Finish		it of Seq					
	1 1	M/ave/Tw	ist in Tui	16	i	Folio	LIOu	itside Di	mensions				

# **Picklist Print**

April-05-13 1:17:41 PM

Page 1

Work Order ID:

99324

Parent Item:

D3126-3

Parent Item Name: Bracket

Start Date: 4/04/13

Required Date: 4/19/13

Start Qty: 4.00

Required Qty: 4.00

**Comments:** 

IPP A03.01.15New issueKJ/RF

IPP Rev:B Now On Water Jet 06-08-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S22GA 304/316 .032 Sheet		Purchased	No			100	sf	209.5600	0.0589	0.248	<u> </u>	_J~	~10-10 <u>-</u> 3
50 N5 10 1052 01101				Location		Loc Qty	Lo	c Code					
				MAT020		209.56							
				1182	271	10.76						·	
				1208	366	55.6							
				1218	389	143.2			191	. <i>288</i>			

										DQA:	Date:	
NCR: Ye	es / No				WORK ORDER NON-C	CONF	ORN	AANCE / UP	DATE	QA Closed:	Date:	
Work Order	:			30.	DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No	).				Rework Scrap Use-as-is Work Order Update	-	۱ Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Ini	tial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other												

### **Landing Gear** General Grain Ovalized Pressure/Forced Bending Bend Temperature/Cure BOM/Route Over/Under tolerance Centre Not Concentric to O/S Hardware Weld Part Incorrect Broken/Damaged Inspection Incomplete Cracks Wrong Stock Pulled Instructions Incomplete/Unclear Part Lost/Missing Crushed/Crimped. Burrs Part Moved Contamination Maintenance Cuffs Countersink Positioned Wrong Mislabeled Heat Treat Power Loss/Surge Other Inspection Strip in Tube Cut Too Short Misread Drill Holes Ripples in Bend Offset Out of Calibration Torque Waves in Extrusion Drawing Finish Out of Sequence Turning Sequence Folio Outside Dimensions Wave/Twist in Tube

**FAULT CATEGORY** 

Process
Supplier
Training
Unapproved

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	99324
Description: Bracket	Part Number:	D3126-3
Inspection Dwg: D3126 Rev: A1	· · · · · · · · · · · · · · · · · · ·	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

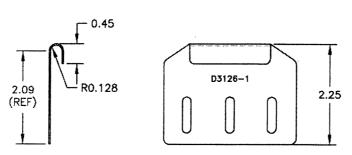
Drawing Dimension	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
	/ 0 010	Dimension			mapection	
1.830	+/-0.010	1.833"			V	Jkno,
2.832	+/-0.010	2.834"	_		V	
<del>3.80</del> 3.005	+/-0.030	3.004"	•		U	
0.200	+/-0.010	0.204"	_		V	
0.800	+/-0.010	0.800	_		V	
0.260	+/-0.010	6.265	1		٧	
1.75	+/-0.030	1.75			5	
					•	
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·						
				,	<u> </u>	
						***
				,		
	-	-				
			DAS			

	•		21		
Measured by:	.In	Audited by:	9-89	Prototype Approval:	N/A
Date:	13-10-27.	Date:	131028	Date:	N/A

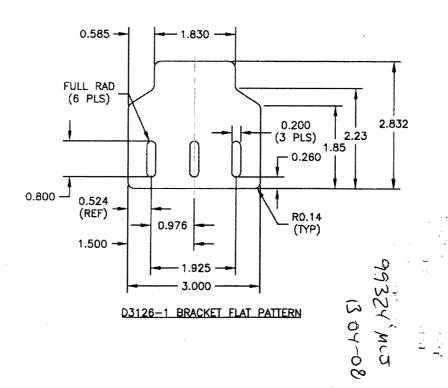
Rev	Date	Change	Revised by	Approved
Α	06.09.19	New Issue	KJ/JLM	all
				<del></del>



	DESIG	"A	DRAWN BY	DART AEROSPACE HAWKESBURY, ONTARIO, CAN	
)	CHEC	KED	APPROVED.	DRAWING NO.	REV. A
<b>'</b>		#	#	D3126	SHEET 1 OF 3
	DATE			TILE	SCALE
	02.0	04.17		BRACKET	1:2
	Α		02.04.17	NEW ISSUE	
	Αı	内业	02.01.23	ADD "ANNEALED" SPEC	



D3126-1 BRACKET
REPLACES PREMIER P/N B30-23000-265



### NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED
  2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  3) ALL DIMENSIONS ARE IN INCHES
  4) BREAK ALL SHARP EDGES 0.005 TO 0.010
  5) SCRIBE DART P/N D3126-1 AS SHOWN

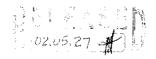
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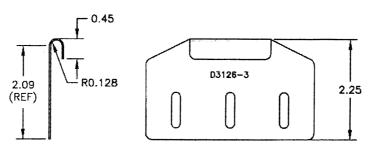
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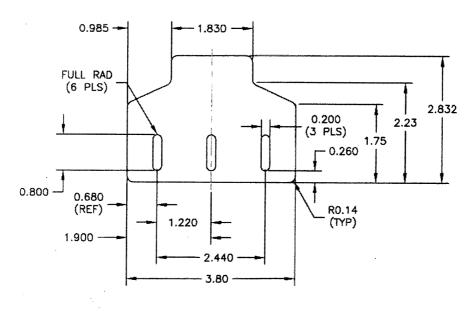


DESIGN #	DRAWN BY		ROSPACE LTD r, ontario, canada
CHECKED	APPROYED	D3126	REV. A SHEET 2 OF 3
DATE		TITLE	SCALE
02.04.17		BRACKET	1:2





D3126-3 BRACKET REPLACES PREMIER P/N B30-23000-267



D3126-3 BRACKET FLAT PATTERN

## NOTES

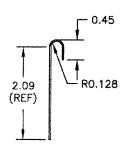
- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

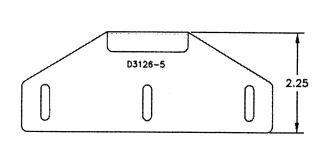
- 3) ALL DIMENSIONS ARE IN INCHES
  4) BREAK ALL SHARP EDGES 0.005 TO 0.010
  5) SCRIBE DART P/N D3126-3 AS SHOWN



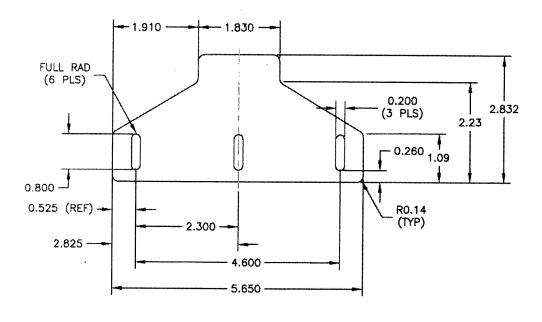


DESIGN #	DRAWN BY		ROSPACE LTD , ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3126	REV. A SHEET 3 OF 3
DATE		TILE	SCALE
02.04.17		BRACKET	1:2





D3126-5 BRACKET REPLACES PREMIER P/N B30-23000-269



D3126-5 BRACKET FLAT PATTERN

- 1) MATERIAL: AISI 304/316 SS SHEET 0.032 THICK PER MIL-S-5059 (REF. DART SPEC. M304S) ANNEALED 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED 3) ALL DIMENSIONS ARE IN INCHES

- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010 5) SCRIBE DART P/N D3126-5 AS SHOWN

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